

Work Order ID 46412

June 29, 2009 10:27:13 AM



Page 1

Item ID: D6101-007

Accept



Setup Start



Revision ID: A

Stop



Item Name: Saddle Billet

Start Date: 15/07/2009 Start Qty: 300.00



Cust Item ID:

Required Date: 03/08/2009 Req'd Qty: 300.00



Customer:

Reference:

Approvals: Process Plan: *WVF*

Date: 09-09-24 Tooling:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D6101

Rev A

100

0.00



Purchasing

PURCHASING

Memo

8393

0.00

Purchasing

Issue P/O: *8393* a) Description: Alluminum billet : b) 7.750" x 8.250" x 2.50" thick : c) Tolerance on all dimensions are +0.030"/-0.000" : d) Grain direction along 7.750" length : e) Material: 7075-T7351 (QQ-A-250/12) : f) Material certification require

C209103/13 (75)

110

0.00



Packaging

Receive & Inspect for Damage & Mat'l Certs

Memo

0.00

Packaging

Ensure material certification is attached

9/3/13

19/9/14 (75)

120

0.00



QC

QC6- Inspect dimensions to drawing

Memo

0.00

Quality Control

Ensure Material certification comply to Dwg D6101

2) 8/2/14

ccnfo (475)

d

Work Order ID 46412

June 29, 2009 10:27:13 AM



Page 2

Item ID: D6101-007

Revision ID: A

Item Name: Saddle Billet

Start Date: 15/07/2009 Start Qty: 300.00

Required Date: 03/08/2009 Req'd Qty: 300.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

C2 09/09/25 75

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/09/28
mf 09-09-26

Picklist Print

June 29, 2009 10:27:13 AM

Page 1

Work Order ID: 46412

Parent Item: D6101-007RevA

Parent Item Name: Saddle Billet




Comments:

Start Date: 15/07/2009

Required Date: 03/08/2009

Start Qty: 300.00

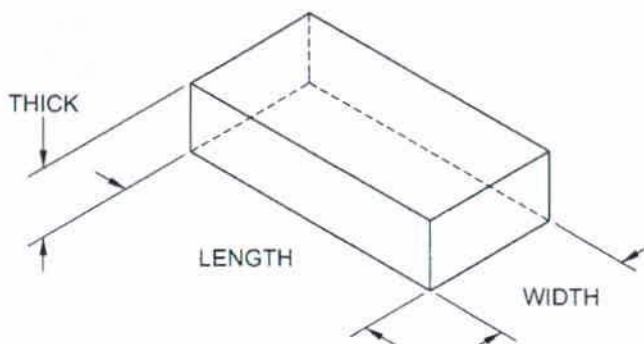
Required Qty: 300.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6101-007PRevA		Purchased	No			110	Each	0.0000	300.0000			
												
7075-T7351 8.25X7.75X2.5												

08/4/24 60

CX09/09/24
W/O: 46412

SPECIFICATION CONTROL DRAWING



REFERENCE ONLY

PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.030/-0.000), AND GRAIN DIRECTION AS SHOWN.

TOLERANCES ON ALL DIMENSIONS ARE +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

△ ACCEPTABLE SPECIFICATIONS FOR 7075-T7351 ALUMINUM ARE AMS-QQ-A-250/12, QQ-A-250/12, OR ASTM B209

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6101-001	7075-T7351 (QQ-A-250/12)	6.000	6.250	2.000	Along 6.000 Length
D6101-003	7075-T7351 (QQ-A-250/12)	7.875	6.250	2.000	Along 7.875 Length
D6101-005	7075-T7351 (QQ-A-250/12)	5.000	8.250	2.500	Along 5.000 Length
D6101-007	7075-T7351 (QQ-A-250/12)	7.750	8.250	2.500	Along 7.750 Length
D6101-009	7075-T7351 (QQ-A-250/12)	8.700	8.250	2.500	Along 8.700 Length
D6101-011	7075-T7351 (QQ-A-250/12)	9.700	8.250	2.500	Along 9.700 Length
D6101-013	7075-T7351 (QQ-A-250/12)	10.100	8.250	2.500	Along 10.10 Length
D6101-015	7075-T7351 (QQ-A-250/12)	9.450	6.250	2.500	Along 9.450 Length
D6101-017	7075-T7351 (QQ-A-250/12)	6.350	6.250	2.250	Along 6.350 Length

△ B

RELEASED
09/07/15 MW

B	ADDED D6101-015/-017, ADD ASTM B209	RF	09.04.23
A	NEW ISSUE	CP	01.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D6101	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SADDLE BILLET, 7075	NTS
DATE	09.04.23	COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

**Castle Metals®**

A. M. Castle & Co.

PACKING SLIP

Page 1 of 1

Pack Slip No:4066359

Ship From: Castle Metals MONTREAL 835-SELKIRK AVENUE POINTE CLAIRE, QUEBEC H9R 3S2		Sold To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7		Ship To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7		Deliver To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA	
Date Shipped 24-SEP-09	F.O.B. ORIGIN	Freight Terms Prepaid		Carrier LOCAL_FLEET	BOL No 69346-5	Delivery No 4066359	

Shipment Details	Final Destination Branch - MON
-------------------------	---------------------------------------

Order No 273463	Line No 3	Item No 6879.MO <i>07/09/24</i>	Description 2.5000.PL.7075.T7351.ALUMINUM.48.5000.144.5000 CUT 2SIDED TO 8.25 IN (+ .0310/- .0000 IN) X 7.75 IN (+ .0310/- .0000 IN)			
Purchase Order No 8393		Part Number YOUR ITEM NUMBER: GRAIN TO RUN ALONG 7.75"		Ordered Qty 75 PCS	Invoice Qty 75 PCS	Backorder Qty
Details						
Mill	Heat Number 422818A5	Mech Id	PCS 75	Width (IN)	Length (IN)	Shipped Qty (LBS) 1211.04

These commodities/technologies are subject to US Export Administration & US State Dept. Regulations and, if intended for export, were/are exported thereunder. Diversion contrary to US Law is Prohibited.

We hereby certify the material covered by this certification conforms in accordance with the above specifications and has been found to meet the applicable requirements for the material, including any specifications forming a part of the description. Test reports are on file subject to examination. All claims for defective material are waived unless made in writing to A.M. Castle & Co. within 60 days of the shipment. Material cut to the correct size, or material cut by the customer cannot be returned for credit.

This material has been received and inspected by:	Date:
---	-------

SHIP TO:

CASTLE METALS
C/O CUTTER PRECISION METALS
1208 NO. 4TH AVE
KENT, WA 98032

SOLD TO:

AM CASTLE & CO
3400 NO. WOLF ROAD
FRANKLIN PARK, IL 60131

KAISER ALUMINUM

Trentwood Works - Spokane, WA 99215

Phone: (800) 367-2586

CERTIFIED TEST REPORT

Serial Number

4128700

CUSTOMER PO NUMBER: 45-24888		WORK PACKAGE:		CUSTOMER PART NUMBER: 6879 A97075-60		SHIP RUN/LOAD ID: 101277/8		GOV'T CONTRACT NUMBER:		
KAISER ORDER NO: 1086888		LINE ITEM: 1	SHIP DATE: 5-MAY-2008		ALLOY: 7075	CLAD: BARE	TEMPER: T7351	PRODUCT DESCRIPTION: MILL FINISH PLATE		
WEIGHT SHIPPED: 3620 LB		QUANTITY: 2 PCS EST.		B/L NUMBER: 2017643		GAUGE: 2.5000 IN		WIDTH: 48.500 IN		LENGTH: 144.500 IN

Certified Specifications

AMS 4078/RevG
ASTM B 209/Rev07
BSS 7055/RevA
DPS 4.713/RevAH
GSS16100/RevG

AMS-QQ-A-250/12
ASTM B 594/Rev06
CMMP 025/RevR
EAC MS1011/RevE
MMS 159/RevN

AMS-STD-2154
BAC 5439/RevH
CSTI 006/RevC
GAMPS 9101/RevB
PS 21211/RevK

Test Code: 4297

Test Results

Lot: 422818A5 Cast 161

Drop 24

Ingot 1

(ASTM E8/B557)

Tensile:	Temper T7351	Dir / # Tests LT / 2 (Min:Max)	Ultimate KSI (MPA) 70.2 : 71.0 (484 : 490)	Yield KSI (MPA) 58.9 : 60.0 (406 : 414)	Elongation % 10.6 : 10.7
----------	-----------------	-----------------------------------	--	---	-----------------------------

(ASTM E1004)

Conductivity %IACS :	40.7 Min	41.7 Max
(MS/M) :	23.6 Min	24.2 Max

(ASTM E1251)

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual	0.09	0.20	1.4	0.05	2.4	0.20	5.6	0.03	0.01	0.01	TOT 0.03

ALLOY LIMITS

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	MAX
7075 MIN	0.00	0.00	1.2	0.00	2.1	0.18	5.1	0.00	0.00	0.00	EACH	0.05
MAX	0.40	0.50	2.0	0.30	2.9	0.28	6.1	0.20	0.05	0.05	TOT	0.15

Aluminum Remainder

**KAISER
ALUMINUM****CERTIFIED TEST REPORT**Trentwood Works - Spokane, WA 99215
Phone: (800) 367-2586Serial Number
4128700**TEST NOTES**

Metal represented by this test report was immersion
ultrasonically tested from one side and meets the Class A
and Class B requirements of all specifications referenced
on this test report.

CASTLE METALS - KENT	
DATE REC'D <u>6-7-08</u>	CUST. _____
REC'D FROM <u>Kaiser</u>	CUST. P.O. _____
APPROVED BY <u>Am</u>	AMC S/O _____
	TR # <u>422818A15</u>
WE HEREBY CERTIFY THAT THESE ARE CORRECT COPIES OF REPORTS NOW ON FILE AT A.M. CASTLE & CO. RY: <u>IAC: 0879</u>	

CERTIFICATION

KAISER ALUMINUM FABRICATED PRODUCTS, LLC (KAISER) HEREBY CERTIFIES THAT METAL SHIPPED UNDER THIS ORDER WAS MELTED IN THE U.S.A OR CANADA AND MANUFACTURED IN THE U.S.A , AND HAS BEEN INSPECTED, TESTED, AND FOUND IN CONFORMANCE WITH THE REQUIREMENTS OF THE APPLICABLE SPECIFICATIONS AS INDICATED HEREIN. ALL METAL WHICH IS SOLUTION HEAT-TREATED COMPLIES WITH AMS 2772. ANY WARRANTY IS LIMITED TO THAT SHOWN ON KAISER'S STANDARD GENERAL TERMS AND CONDITIONS OF SALE. TEST REPORTS ARE ON FILE, SUBJECT TO EXAMINATION. TEST REPORTS SHALL NOT BE REPRODUCED EXCEPT IN FULL, WITHOUT THE WRITTEN APPROVAL OF ALUMINUM FABRICATED PRODUCTS, LLC LABORATORY. THE RECORDING OF FALSE, FICTITIOUS, OR FRAUDULANT STATEMENTS OR ENTRIES ON THE CERTIFICATE MAY BE PUNISHED AS A FELONY UNDER FEDERAL LAW. ISO-9001:2000 CERTIFIED

BILL POYNOR, LABORATORIES SUPERVISOR